Электрические тигельные печи Т

Технические характеристики

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Bale-Out Furnaces T
Electrically Heated, for Melting and Holding

Whether in manual pouring operation or integrated in an automated casting cell, the electrically heated tilting furnaces are characterized by very good melt quality, optimum energy efficiency and low-maintenance operation. These furnaces are available with reduced connected load for only holding of aluminum alloys or with increased power for holding and melting as allrounders.

Bale-out furnace T 110/11

Standard Equipment

- T ../10 for holding aluminum alloys
- T ../11 for melting and holding aluminum and zinc alloys
- T ../13 for melting and holding copper alloys such as bronze or brass
- Free radiating heating elements arranged on four sides on support tubes provide for long service life and easy replacement
- Twelve months warranty on heating elements
- High melting performance with temperature uniformity in the melt
- Multi-layer insulation for optimum energy efficiency and low external wall temperatures
- Emergency outlet for safe draining of the melt in case of crucible breakage
- No exhaust gas discharge needed
- Integrated safety system which continues to operate the furnace at reduced power in case of malfunction in the thermocouple, in order to prevent the freezing of the melt
- Over-temperature limiter in furnace chamber for protection against overheating. The limiter switches the heating off when the set limit temperature is reached, and only switches it back on after the temperature has fallen again.
- Low-maintenance furnace chamber control with temperature measurement behind the crucible

Bale-out furnace T 800/11

Additional Equipment

- Crucible of clay-graphite or SiC
- Collecting pan under the emergency outlet see page 39
- Crucible breakage monitor with visual and audible signal (not for T ../13)
- Bath control with thermocouples in the furnace chamber and in the melt (not for T ../13). The furnace temperature is controlled through the melt. Temperature overshoots are reduced, thus the quality of the melt is improved
- Heating system operated through thyristors
- Multi-step switching of the furnace heat (see page 43)
- Higher electrical ratings to increase melting performance
- Work platform for ease of charging
- Alarm message via SMS, e. g. in the event of crucible breakage
- Process control and documentation via Nabertherm Control Center (NCC) for monitoring, documentation and control see page 42
- For information on other accessories see page 38 - 39

Bale-out furnace T 80/13 for gunmetal in a sand foundry shop

Model	Tmax furnace	Tmax melt bath	Crucible	Capacity in kg			Heating power	Melting performance[3,6]	Consumption melting[6]	Consumption holding Lid closed/open	Outer dimensions[5] in mm			Weight
	°C	°C		Al	Zn	Cu	in kW[4]	in kg/h	kWh/kg	kWh/h	W	D	H	in kg
T 80/10	1000	800	BU 200	200	-	-	20	-	-	4/9[1]	1110	1110	940	1050
T 110/10	1000	800	BU 300	300	-	-	26	-	-	5/10[1]	1200	1200	1040	1240
T 150/10	1000	800	BU 350	350	-	-	38	-	-	5/10[1]	1200	1200	1140	1330
T 180/10	1000	800	BU 500	500	-	-	42	-	-	7/15[1]	1370	1370	1250	1400
T 240/10	1000	800	BU 600	600	-	-	50	-	-	7/15[1]	1370	1370	1350	1530
T 360/10	1000	800	BN 800	800	-	-	50	-	-	8/17[1]	1510	1510	1490	2000
T 450/10	1000	800	BU 1800 H 830	970	-	-	50	-	-	13/20[1]	1685	1685	1360	2400
T 560/10	1000	800	BU 1800 H 1000	1230	-	-	50	-	-	13/23[1]	1685	1685	1530	2550
T 800/10	1000	800	BU 1800	1800	-	-	70	-	-	15/25[1]	1685	1685	1830	2800
								Al	Al					
T 10/11	1100	950	A 70	20	50	-	16	32[1]	0.4[1]	3/5[1]	860	860	790	550
T 20/11	1100	950	A 150	45	110	-	20	42[1]	0.4[1]	3/6[1]	940	940	790	650
T 40/11	1100	950	A 300	90	230	-	26	58[1]	0.4[1]	3/7[1]	1010	1010	880	750
T 80/11	1100	950	BU 200	200	520		50	126[1]	0.4[1]	4/9[1]	1110	1110	940	1050
T 110/11	1100	950	BU 300	300	790	-	60	136[1]	0.4[1]	5/10[1]	1200	1200	1040	1240
T 150/11	1100	950	BU 350	350	920	-	60	147[1]	0.4[1]	5/10[1]	1200	1200	1140	1330
T 180/11	1100	950	BU 500	500	1320	-	70	168[1]	0.4[1]	7/15[1]	1370	1370	1250	1400
T 240/11	1100	950	BU 600	600	1580	-	80	180[1]	0.4[1]	7/15[1]	1370	1370	1350	1530
T 360/11	1100	950	BN 800	800	2110	-	110	200[1]	0.4[1]	8/17[1]	1510	1510	1490	2000
T 450/11	1100	950	BU 1800 H 830	970	2570	-	110	200[1]	0.4[1]	13/20[1]	1685	1685	1360	2400
T 560/11	1100	950	BU 1800 H 1000	1230	3250	-	110	220[1]	0.4[1]	13/23[1]	1685	1685	1530	2550
T 800/11	1100	950	BU 1800	1800	4750	-	140	240[1]	0.4[1]	15/25[1]	1685	1685	1830	2800
								Cu	Cu					
T 10/13	1300	1150	A 70	20	-	70	16	47[2]	0.3[2]	5/8[2]	900	900	890	650
T 20/13	1300	1150	A 150	45	-	150	20	63[2]	0.3[2]	5/10[2]	980	980	890	780
T 40/13	1300	1150	A 300	90	-	300	26	84[2]	0.3[2]	5/12[2]	1050	1050	970	960
T 80/13	1300	1150	BU 200	200	-	650	50	190[2]	0.3[2]	5/15[2]	1150	1150	1030	1200

[1]Al at 700 °C
[2]CuZn at 1000 °C
[3]The specified melting performances are maximum values. In practice, approx. 80 % are achieved. Values for other materials, e. g. zinc, on request.
[4]Depending on furnace design connected load might be higher
[5]External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
[6] Values for other materials, e. g. zinc, on request

Bale-out of bale-out furnace with robot

Four side heating for excellent temperature uniformity

Manual ladling from a bale-out furnace T 80/10

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